

Date: Tuesday, 06/03/2007 2:30:29 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 30293	
Estimate Number : 11173	
P.O. Number : <i>N/A</i>	Part Number : D32851
This Issue : 06/03/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3285 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30293	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 13/03/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 20 Um: Each
Comment : Est. A04.07.14 New issue KJ/JLM Est Rev:B Now on Waterjet 07-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.1603 sf(s)/Unit Total : 3.2067 sf(s)

6061-T6 .080 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.080" thick or 5052-H32 (QQ-A-250/8) 0.080" thick
(M6061T6S.080 or M5052H32S.080)

Identify for D3285-1

Batch: *M 103434 ml 07 03 07*

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3285

Dwg Rev: *A*

Prog Rev: *A*

ml 07 03 07

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 07

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07/03/07 (20)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 30293

Part Number: D32851

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

m-h / 50 7-3-8 (20)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/08 (20)

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/03/08 (20) a

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/03/09 (20)

Job Completion



07/03/09

Date: Tuesday, 1/16/2007 11:33:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30293
 Estimate Number : 11173
 P.O. Number :
 This Issue : 1/16/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : MACHINED PARTS
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est. A04.07.14 New issue KJ/JLM

Drawing Name : CAP
 Part Number : D32851
 Drawing Number : D3285 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 1/30/2007

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty: 0.1603 sf(s)/Unit Total: 0.6413 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 (QQ-A-250/11) 0.080" thick or 5052-H32 (QQ-A-250/8) 0.080" thick (M6061T6S.080 or M5052H32S.080) Identify for D3285-1 Batch:		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blanks: 6.375" x 3.200"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA435 and Dwg D3285 Deburr Identify as D3285-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:33:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 30293

Part Number: D32851

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

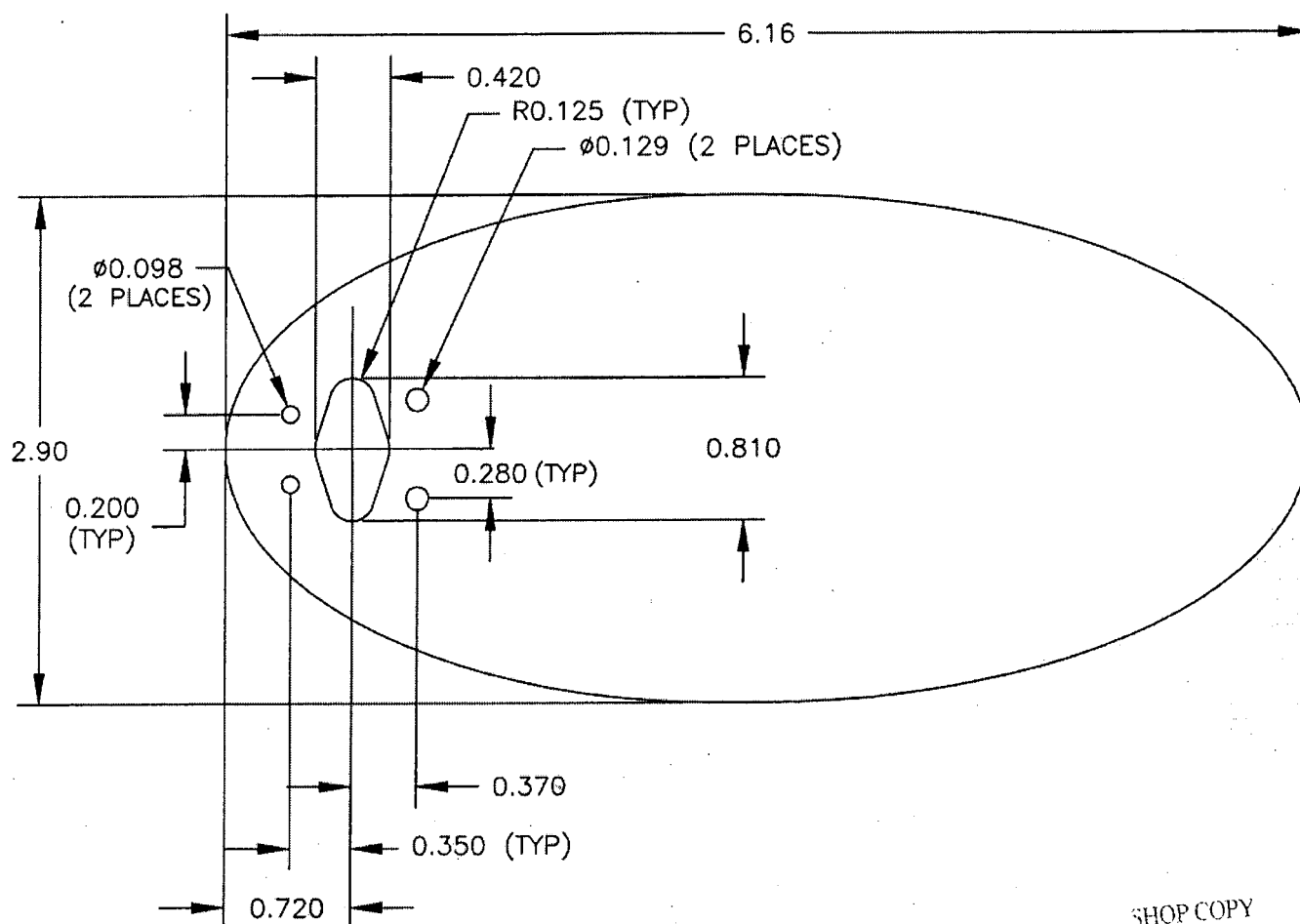
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN UP	DRAWN BY UP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3285	REV. A SHEET 1 OF 1
DATE 04.05.08		TITLE CAP	SCALE 1:1
A	04.05.08	NEW ISSUE	

RELEASED
04.06.22



D3285-1 CAP

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8) 0.080 THICK
- 2) ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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NO. 30293

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